

EPODOC / EPO

PN - DE19613134 A1 19971002

PD - 1997-10-02

PR - DE19961013134 19960401

OPD - 1996-04-01

TI - (A1)

Hollow plastic product manufacture and process plant

AB - (A1)

In a process for moulding a plastic product(6) with one or more hollow chambers a polymer melt is injected into a tool cavity(2) and simultaneously or subsequently a first pressurised fluid, preferably compressed gas, is injected into the melt via a nozzle(7) to form a hollow cavity and press the melt against the cavity walls. A second pressurised fluid, preferably a compressed gas, is also injected into the cavity(2) at a pressure(PGG) greater than atmospheric and acts against the melt flow to control growth of the internal gas bubble. Process equipment comprises a tool(1) with one or more cavities(2), an injection unit(4,5) with a melt injection nozzle(3), an injection nozzle(7) for injecting the first pressurised fluid and an arrangement(8) for injecting the second pressurised fluid into the cavity(2).

IN - (A1 C2)

ECKARDT HELMUT [DE]; EHRITT JUERGEN [DE]

PA - (A1 C2)

BATTENFELD GMBH [DE]

EC - B29C45/17B; B29C45/17B2

IC - (A1)

B29C45/03

- (C2)

B29C45/00

CT - (A1 C2)

DE3913109 C2 [ ]; DE2800482 A1 [ ];

US4101617 A [ ]

WPI / DERWENT

TI - Hollow plastic product manufacture and process plant - which injects melt into tool cavity, followed by pressurised fluid to create hollow chamber and simultaneously feeding second pressurised fluid cavity to control the melt flow

PR - DE19961013134 19960401

PN - DE19613134 C2 20000727 DW200037 B29C45/00 000pp

- DE19613134 A1 19971002 DW199745 B29C45/03 013pp

PA - (BATW ) BATTENFELD GMBH

IC - B29C45/00 ;B29C45/03

IN - ECKARDT H; EHRITT J

AB - DE19613134 In a process for moulding a plastic product(6) with one or more hollow chambers a polymer melt is injected into a tool cavity(2) and simultaneously or subsequently a first pressurised fluid, preferably compressed gas, is injected into the melt via a nozzle(7) to form a hollow cavity and press the melt against the cavity walls. A second pressurised fluid, preferably a compressed gas, is also injected into the cavity(2) at a pressure(PGG) greater than atmospheric and acts against the melt flow to control growth of the internal gas bubble. Process equipment comprises a tool(1) with one or more cavities(2), an injection unit(4,5) with a melt injection nozzle(3), an injection nozzle(7) for injecting the first pressurised fluid and an arrangement(8) for injecting the second pressurised fluid into the cavity(2).

- ADVANTAGE - Better surface quality is achieved by a more controlled melt flow which prevents the gas bubble breaking through the melt.

- (Dwg.1/9)

OPD - 1996-04-01

AN - 1997-481907 [45]

